

Date: Tuesday, 1/16/2007 11:33:40 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FLOAT WEB  
 Job Number : 30292  
 Estimate Number : 10791  
 P.O. Number : N/A Part Number : D3282041  
 This Issue : 1/16/2007 S.O. No. : N/A Drawing Number : D3282 REV C  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : C  
 Previous Run : 25435 Material : N/A  
 Due Date : 1/30/2007 Qty: 4 Um: Each  
 Written By : KJ 07.01.16  
 Checked & Approved By : KJ 07.01.16  
 Comment : Est Rev:B 05.09.23 Procedure change KJ/JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2792130 EXTRUSION



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2792-130 Extrusion B24030

KJ 07-02-27

Identify as D3282-1

2.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Cut to length as per Dwg D3282.

KJ 07-02-27

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA579 & Dwg D3282

2-Deburr

J.F./MS 07/03/08 4

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F./MS 07/03/08 4

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

EA 07/03/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 1/16/2007 11:33:40 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT WEB

Job Number: 30292

Part Number: D3282041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

1/K 07-03-15

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

4T 07-03-15

8.0

D32831

Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3283-1

Doubler

B 25339

1/K 07-03-15

9.0

MS20470AD47

Rivet, Universal Head



Comment: Qty.: 57.0000 Each(s)/Unit Total: 228.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

57 MS20470AD4-7

Rivet

M 100854

1/K 07-03-15

10.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install doublers as per Dwg D3282. Apply LPS-3 between doublers and web

A/RN/ALPS-3 M 103674

1/K 07-03-15

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07-03-17

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LG

1/K 07-03-29 (4)

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/03/30

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 1/16/2007 11:33:40 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT WEB

Job Number: 30292

Part Number: D3282041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



(4)

Comment: FINAL INSPECTION/W/O RELEASE

07/03/30

Job Completion



07-03-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

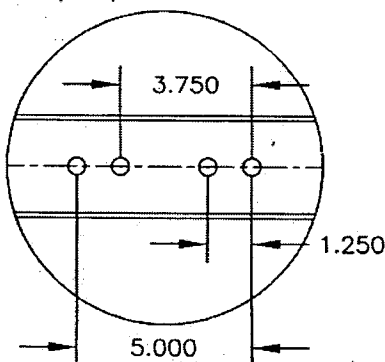
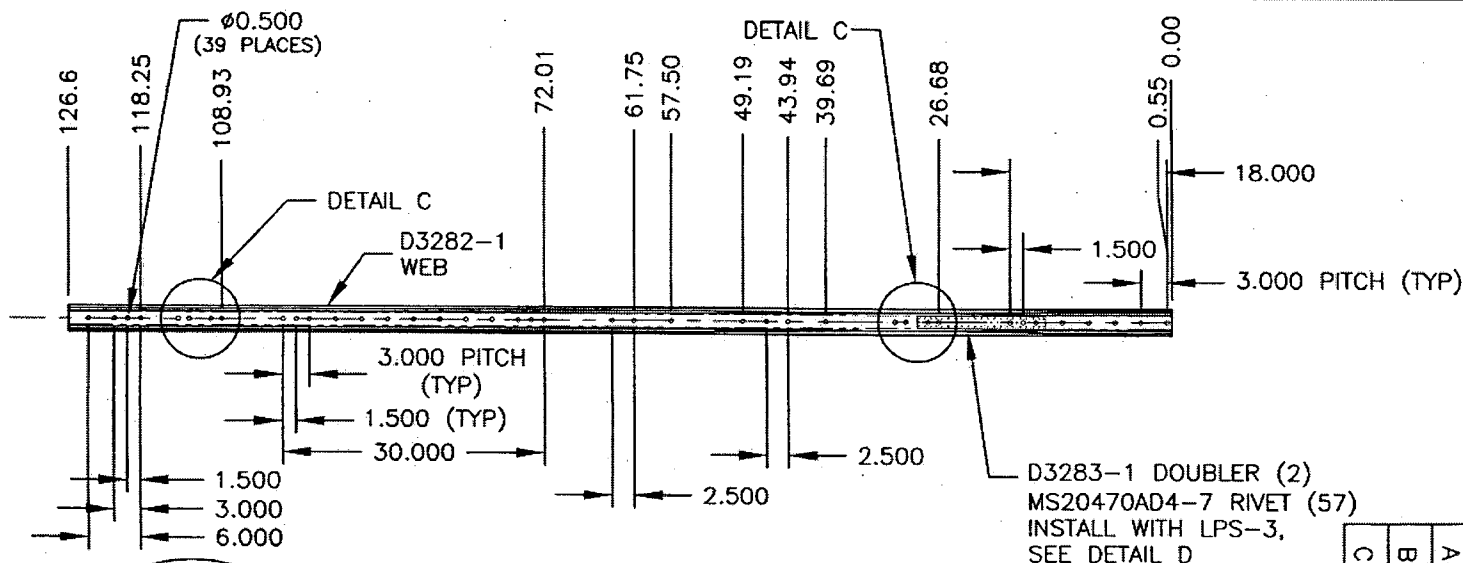
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

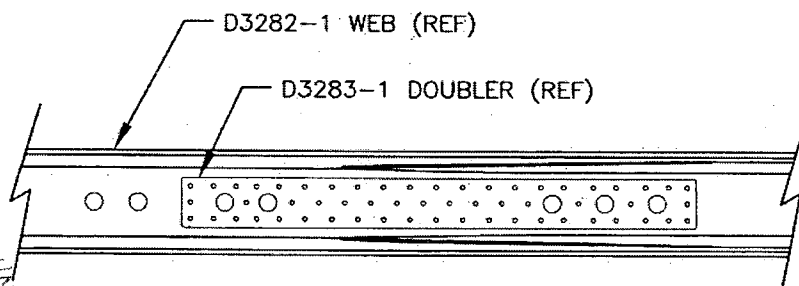
NOTE: Date & initial all entries

**DART**

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
CP	CP	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. C
#	#	D3282	SHEET 1 OF 2
DATE		TITLE	SCALE
05.08.09		FLOAT WEB, 206L/407	1:20
A	04.05.05	NEW ISSUE	
B	05.03.16	MOVE HOLES, ADD D3390-1 DOUBLERS	
C	05.08.09	REMOVE D3390-1, NOW MACHINED	



**DETAIL C**  
SCALE 1:5  
RIVET HOLES NOT SHOWN  
FOR CLARITY



**DETAIL D**  
SCALE 1:5

**D3282-041 FLOAT WEB**

- 1) MAKE FROM D2792-130 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) APPLY A LAYER OF LPS LABORATORIES' LPS-3 BETWEEN D3283-1 DOUBLERS AND D3282-1 WEB. INSTALL RIVETS COATED WITH LPS-3
- 6) SEE PAGE 2 FOR MACHINING DETAILS

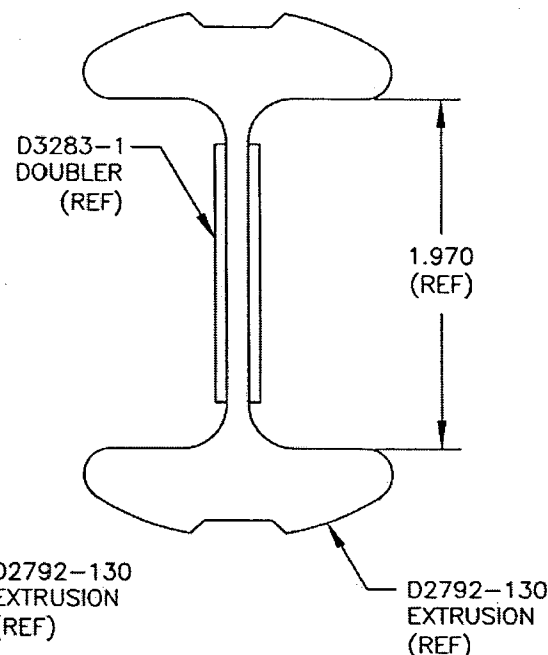
NO. 30292  
WORK ORDER  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
UNCONTROLLED COPY  
ENGINEERING  
RETURN TO  
SHOP COPY

RELEASED  
05.09.12

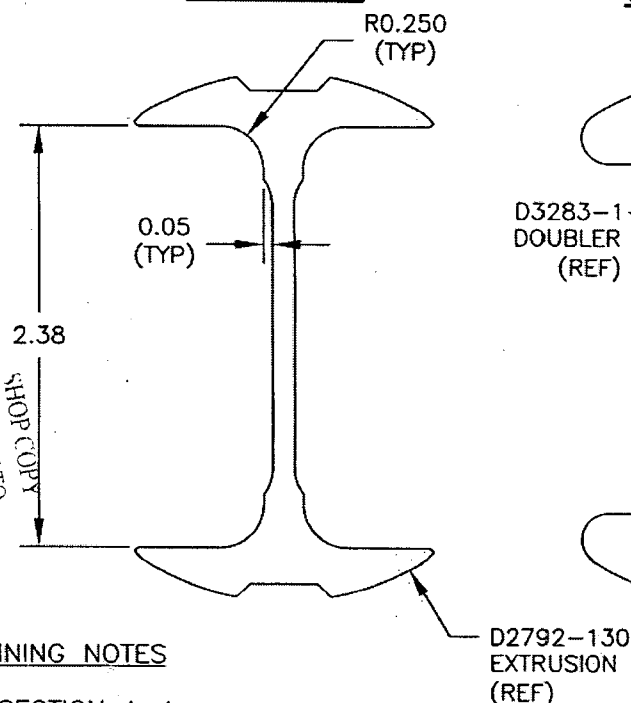
**DART**

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE USA, INC.	REV. C
CHECKED	#	APPROVED	#	PORT HADLOCK, WA	SHEET 2 OF 2
DATE	05.08.09	TITLE	D3282	FLOAT WEB, 206L/407	SCALE
					1:20

## SECTION B-B



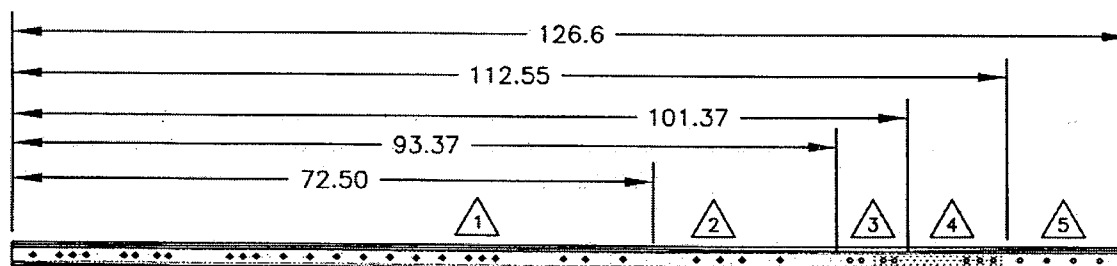
## SECTION A-A



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 30292

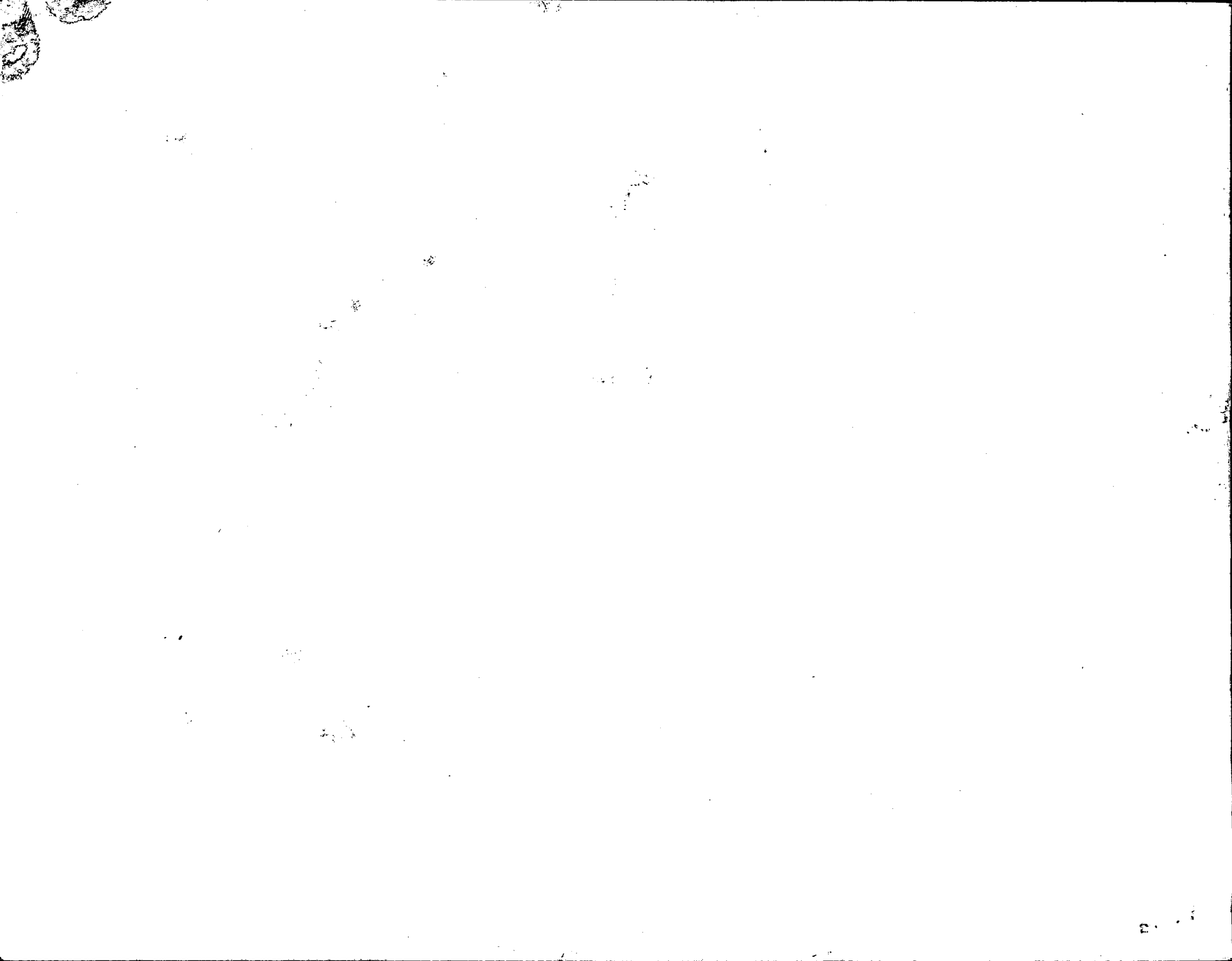
### D3282-1 MACHINING NOTES

- 1 UNIFORM SECTION A-A
- 2 UNIFORM TAPER FROM SECTION A-A TO SECTION B-B
- 3 UNIFORM SECTION B-B
- 4 UNIFORM TAPER FROM SECTION B-B TO SECTION A-A
- 4 DRILL #30 (Ø0.128 REF) HOLES (57 PLACES) TO LINE UP WITH D3283-1, SEE DETAIL D FOR REFERENCE
- 5 UNIFORM SECTION A-A
- 6 R1.00 BETWEEN SECTIONS



RELEASED  
05-09-12





<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 30292
<b>Description:</b> Float Web		<b>Part Number:</b> D3282-041
<b>Inspection Dwg:</b> D3282 , Rev: C		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
126.6	± .030	126.6	✓			
1.500	± .010	1.500	✓			
3.000	"	3.000	✓			
6.000	"	6.000	✓			
1.250	"	1.250	✓			
30.000	"	30.000	✓			
1.500	"	1.500	✓			
72.01	± .030	72.00	✓			
61.75	"	61.75	✓			
57.50	"	57.50	✓			
49.19	"	49.20	✓			
43.94	"	43.95	✓			
39.69	"	39.70	✓			
26.68	"	26.68	✓			
.55	"	.55	✓			
1.970	± .010	1.970	✓			
2.38	± .030	2.378	✓			
.05	"	.05	✓			

<b>Measured by:</b>	MS
<b>Date:</b>	07/03/08

<b>Audited by:</b>	<i>[Signature]</i>
<b>Date:</b>	07/03/09

<b>Prototype Approval:</b>	N/A
<b>Date:</b>	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	